

35

| | | |
|----------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 21373 |
| Description: Bushing | Part Number: | D2617-5 |
| Dwg: D2617 Rev. D1 | Qty: | 24 29 |
| | | Page 1 of 1 |

| Step | Location | Procedure | By | Date | Qty |
|------|----------|---|-----|----------|-----|
| 1 | DC | Issue Traveler | 4 | 04.08.23 | 24 |
| 2 | MC | Machine as per Folio FA438 and Dwg D2617 Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6) Ø0.500" tubing x 0.058" wall (M6061T6T0.500W.058) Identify as D2617-5 | SB | 04/08/24 | 29 |
| 3 | QC2 | Inspect parts as they come off the CNC machine | SB | 04/08/24 | 29 |
| 4 | QC8 | Second check | 10 | 04.08.25 | 29 |
| 5 | GA | Deburr break all unmarked sharp edges 0.005 to 0.010 | SB | 04/08/25 | 29 |
| 6 | FP | Acid Etch and Alodine as per QSI 005 4.1 | 9M | 04.08.25 | 29 |
| 7 | QC5 | Inspect work to Step 6 | 10 | 04.08.25 | 29 |
| 8 | ST | Identify and Stock | CD | 04/08/25 | 29 |
| 9 | AC | Cost / part: 1.67 | 54C | 04.08.26 | 29 |
| 10 | DC | Close W/O 3.29 Inspect Level 21 | 4 | 04.08.26 | 29 |

| Rev | Date | Change | Revised By | Approved |
|-----|----------|---|------------|--------------------|
| D | 98.04.16 | Re-Format | KB | |
| E | 99.08.23 | Re-format, added notes and inspection level | EC | |
| F | 01.01.03 | Re-format, made in-house | EC | |
| G | 01.01.08 | Updated material NCR 467 | EC | |
| H | 04.07.14 | Reformat; added step 5 | KJ/JLM | <i>[Signature]</i> |

RELEASED

04/07/14

| Work Order: | | WORK ORDER CHANGES | | | | | | | |
|-------------|------|--------------------|--|--|----|------|-----|-----------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Manuf / Design Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |

| NCR | | WORK ORDER NON-CONFORMANCE | | | | | | |
|------|------|--------------------------------|--------------------------------|--|--|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial | | | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date: _____

| | | |
|-----------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 21373 |
| Description: Bushing | Part Number: | D2617-5 |
| Inspection Dwg: D2617 | Rev: D1 | Page 1 of 1 |

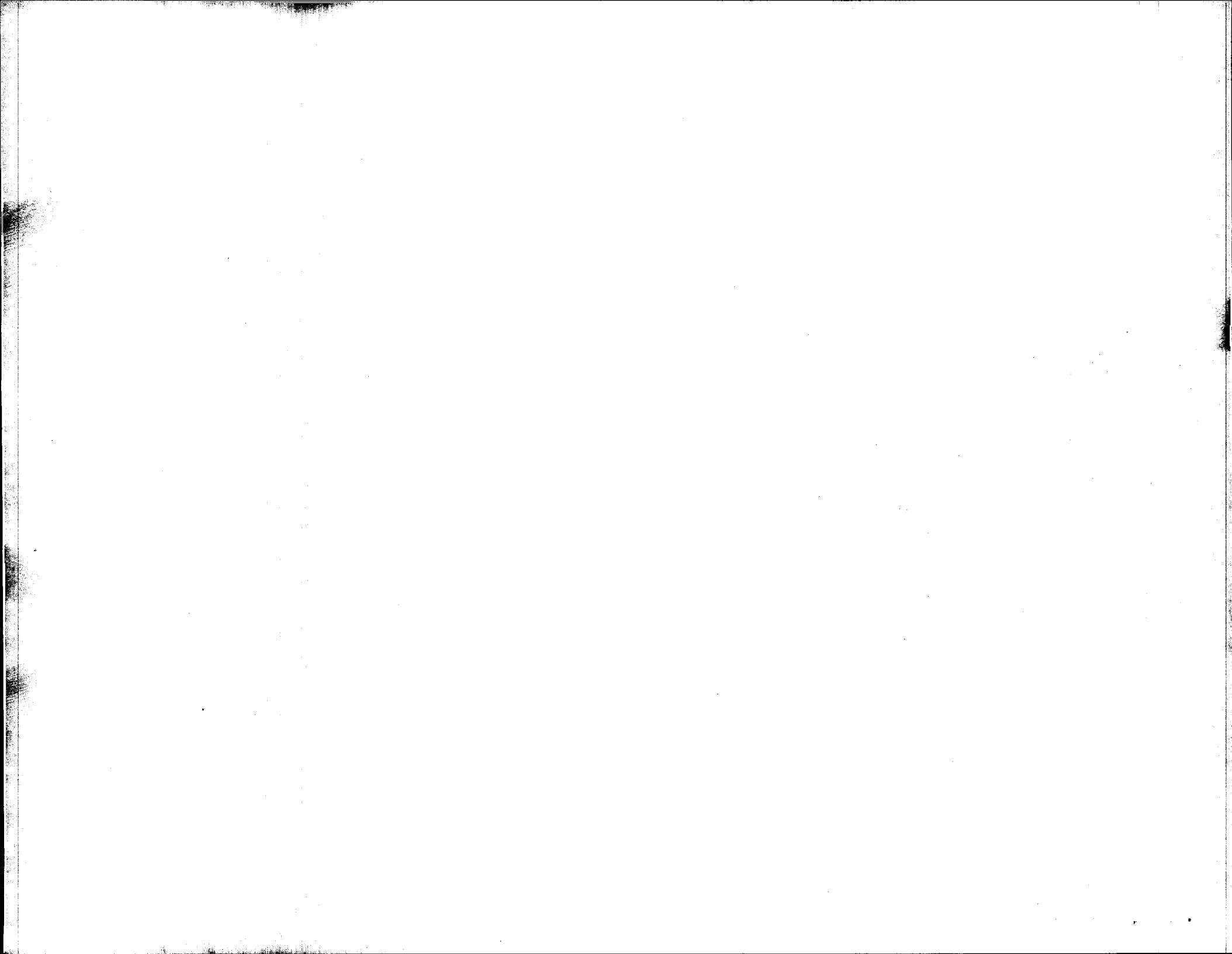
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | | | | |
|--------------|-----------------|-------------|-----------------|---------------------|-----|
| Measured by: | <i>SL</i> | Audited by: | <i>RB</i> | Prototype Approval: | N/A |
| Date: | <i>07/05/24</i> | Date: | <i>01-06-25</i> | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 04.08.09 | New Issue | KJ/JLM | |

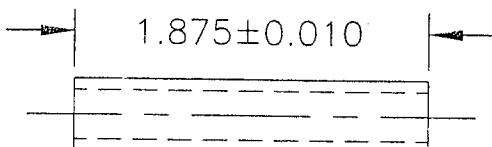
RELEASED
~~July 01, 1988 - 11~~



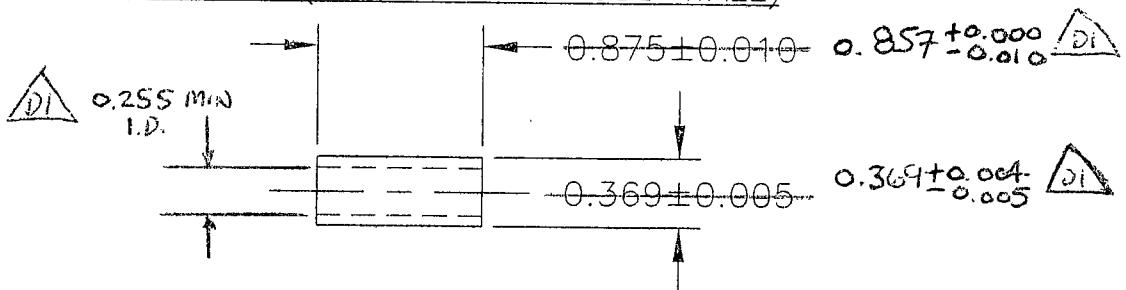


| | | | | |
|---------|-------------|-----------------------------------|-----------------------------|--------------------------|
| DESIGN | BW | DRAWN BY | CP | DART AEROSPACE LTD |
| CHECKED | <i>✓</i> | APPROVED | <i>✓</i> | DRAWING NO. D2617 REV. D |
| DATE | 01.07.04 | | | SHEET 1 OF 1 |
| | | | | SCALE 1:1 |
| A | 96.10.08 | NEW ISSUE | | |
| B | 97.05.08 | .875 WAS 1.125 | | |
| C | 97.06.04 | 0.369 DIA WAS 0.375 | | |
| D | 01.07.04 | ADD MAT'L SPEC AND TOL./DIM. NOTE | | |
| DI | <i>CP-1</i> | <i>04.07.12</i> | CORRECT TOLERANCE (NCR 779) | |

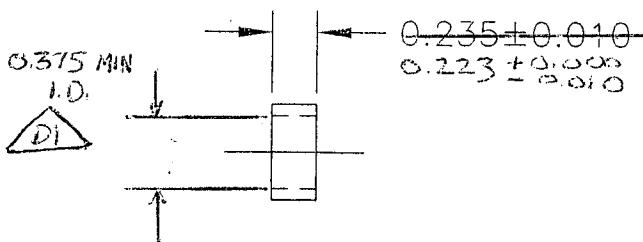
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05 *CP*

SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 21373

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 23, 2004
09:50 am

Work Order No : 0021373
 Project Name : D2617-5
 Project For : WK435
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2617-5
 Description : Spacer
 Manufactured : Yes
 Amount Req'd : 24
 Amount Done : 0
 Start Date : 08-20-04
 Est Finish Date : 08-26-04
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Margin : 0.000%
 Actual Margin : 0.000%

| | Estimated | Actual | Var. % | Posted | To Post |
|---------------------|-----------|--------|--------|--------|---------|
| Material Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours : | 0.00 | 0.00 | 0.00 | | |
| Engineering Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours : | 0.00 | 0.00 | 0.00 | | |
| Production Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Packaging Hours : | 0.00 | 0.00 | 0.00 | | |
| Packaging Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours : | 0.00 | 0.00 | 0.00 | | |
| OverHead Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours : | 0.00 | 0.00 | 0.00 | | |
| CNC : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours : | 0.00 | 0.00 | 0.00 | | |
| Misc. : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| ===== | | ===== | ===== | | |
| Burden : | 0.00 | 0.00 | 0.00 | | |
| ===== | | ===== | ===== | | |
| Total Cost : | 0.00 | 0.00 | 0.00 | | |
| Margin : | 0.000 | 0.000 | | | |
| Selling Cost : | 0.00 | 0.00 | | | |

| | Estimated | Actual |
|--------------------------|-----------|--------|
| Labour Hrs/Amount Done : | 0.00 | 0.00 |
| Profits/ (Loss) : | 0.00 | 0.00 |